

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT ASSEMBLY
Job Number	: 31838		
Estimate Number	: 10464		
P.O. Number	: N/A	Part Number	: D3278041
This Issue	: 4/17/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3278 REV. B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 31661	Drawing Revision	: B
		Material	: N/A
		Due Date	: 4/24/2007
Written By	: <u>[Signature]</u>	Qty:	18
Checked & Approved By	: <u>[Signature]</u>	Um:	30
Comment	: Est:A 04.04.19 New issue KJ/JLM	Each	

Job Number:



10 31838A SUPPORT



✓ sub

Comment: Sub-Component SUPPORT ~~B32657 X16~~ B32657 X2  
D3278-1 B            B31735 X16

2.0	31838B	SUPPORT
-----	--------	---------



Comment: Sub-Component SUPPORT

D3278-2 B 31838 ~~31838~~ 18

*[Signature]*

3.0	D32783	Spacer
-----	--------	--------



**Comment:** Qty.: 1.0000 Each(s)/Unit      Total: 30.0000 Each(s)

Spacer

Pick:

Qty	Part Number
-----	-------------

### Description

Batch

1 D3278-3

Spacer

B31704 x 18

*[Signature]*

4.0	MS20426AD37	RIVET
-----	-------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~120.0000~~ Each(s)

RIVET

Pick:

Qty	Part Number
-----	-------------

### Description

Batch

4 MS20426.

Rivet

m 16527

5.0 ~~2~~ SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



P.T.O.

Comment: SMALL & MEDIUM FAB RESOURCE 1  
Rivet spacers with support as per Dwg D3278.

ml 07/07/24

x17



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/24	5	Bad installation of rivets. And 6 ms 2426AD3-7 (Rev 1) Scrap one D3278-2/1 and D3278-3	<i>[Signature]</i> 05/07/24	Scrap and no replace (complete Assembly)	<i>[Signature]</i> 07/07/24	<i>[Signature]</i> 07/07/24	<i>[Signature]</i> 05/07/24	<i>[Signature]</i> 07/07/24
		RC Human Error						

NOTE: Date & initial all entries



Date: Tuesday, 4/17/2007 11:05:30 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 31838

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/24 x17

7.0

D22301

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~80.0000~~ Each(s)

Mounting Lug

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2230-1

Mounting Lug

B32163

✓ ml

8.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~80.0000~~ Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4-13A

Bolt

M104746

✓ ml

9.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~120.0000~~ Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN960JD416

Washer

M104215

✓ ml

10.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~80.0000~~ Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21042L4

Nut

M102552

✓ ml 07/07/24

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

\*\*\*DO NOT TIGHTEN BOLTS\*\*\*

Identify as D3278-041

x17

ml 07/07/24



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Tuesday, 4/17/2007 11:05:30 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 31838

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/21 (+17) *call*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/2/25 (17X) SP

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(17) *OK 7/25*

Job Completion



*U 8-07-25*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

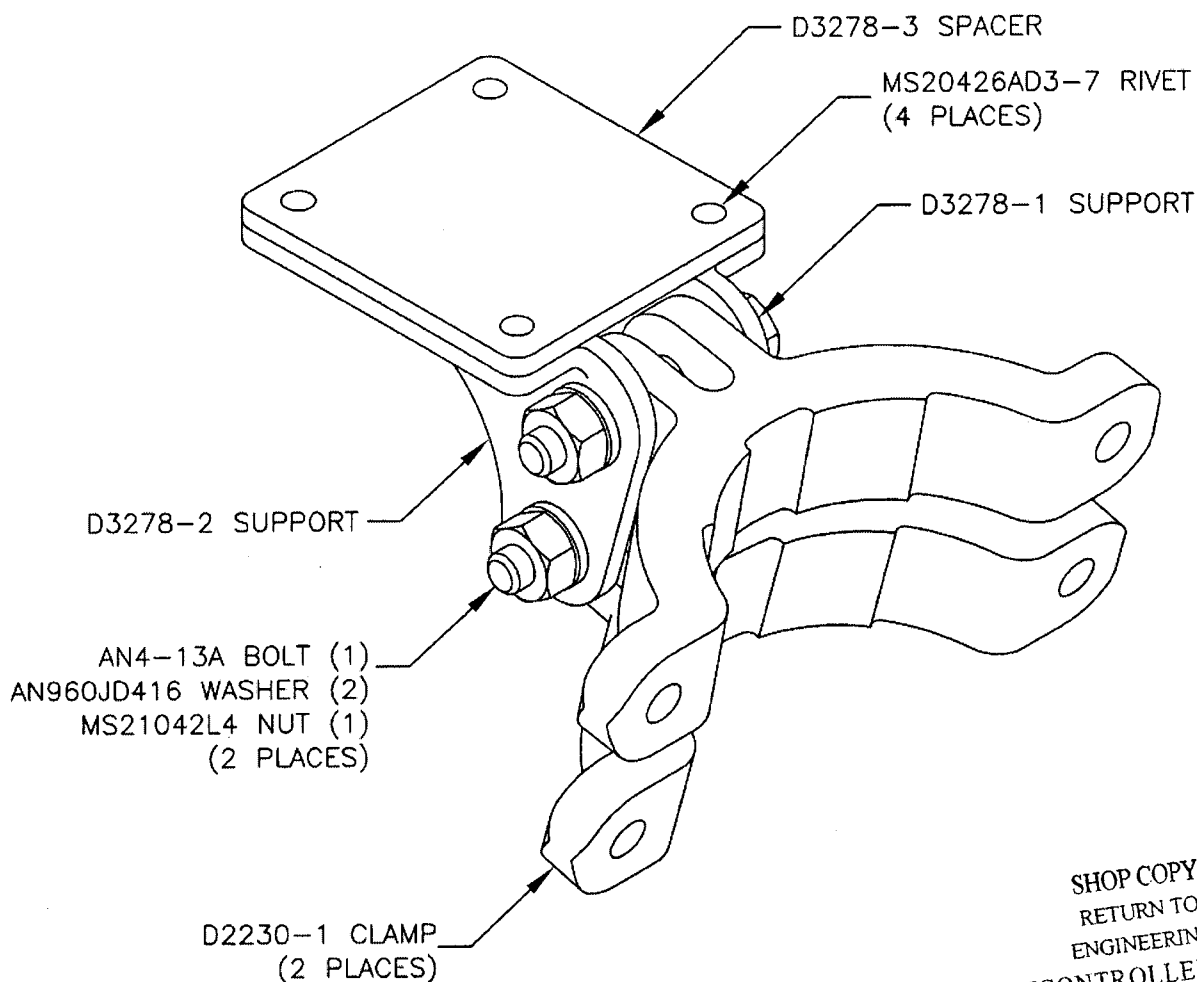




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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE	05.03.31			TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03			NEW ISSUE	
B	05.03.31			CHANGE DIM/TOL TO ENSURE FIT	

RELEASED  
05.04.04 *[Signature]*

## D3278-041 SUPPORT ASSEMBLY



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NO. 31838

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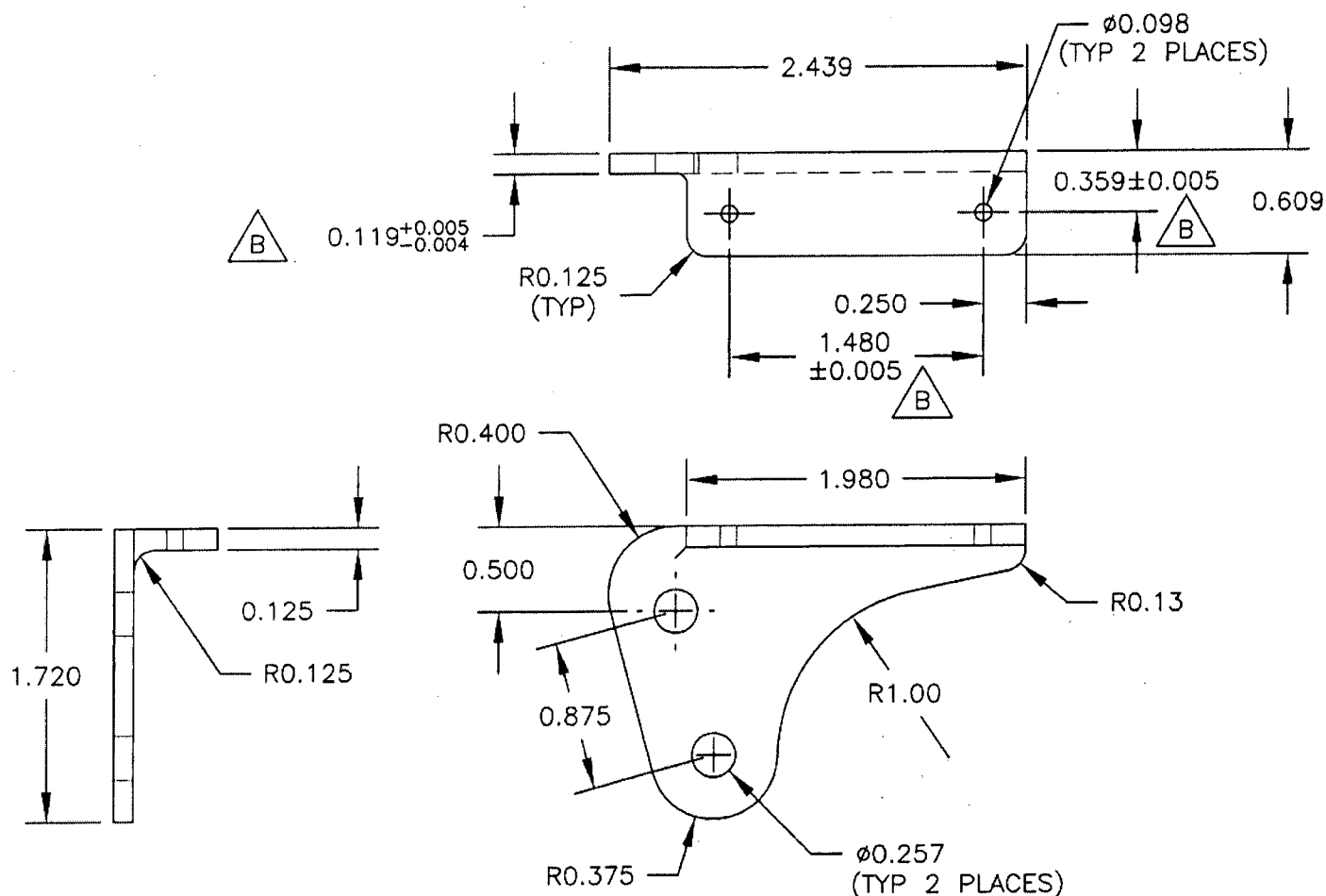




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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 2 OF 3
DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED

05.04.04 *[Signature]*



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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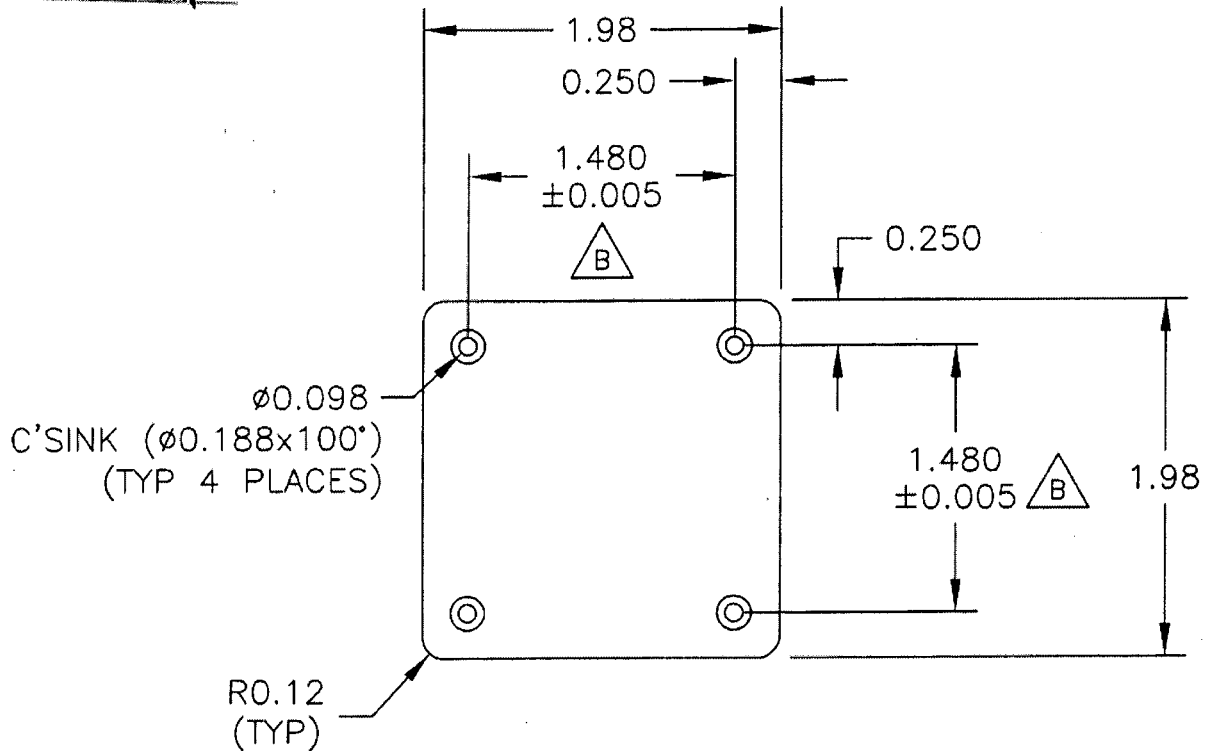
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**05.04.04 *[Signature]***D3278-3 SPACER**

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-C  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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